Work Order ID 109425

109425

November-21-13 2:23:06 PM

D3294-1
B109425

Item ID: D3294-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Bracket For Interior Window For -115

Start Date: 11/21/13 **Start Qty:** 6.00 *6*
Required Date: 11/21/13 **Req'd Qty:** 6.00 *6*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** MCS **Date:** 13-11-25 **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3294	D								
100		0.00							
100						6	0		JmB-12-7
Waterjet	**Memo**	0.00							Ae 13-12-11
FLOW CNC Waterjet	1-Cut as per Dwg D3294 CUt File D3294-3 Dwg Rev: D Prog Rev: D								
	*grain direction on a 45 deg as per dwg**								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						6	0		JmB-12-7
QC	**Memo**	0.00							Ae 13-12-11
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Item ID: D3294-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Bracket For Interior Window For -115
Start Date: 11/21/13 **Start Qty:** 6.00 *6*
Required Date: 11/21/13 **Req'd Qty:** 6.00 *6*
Reference:
Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				6			
120		0.00 13/12/19							
QC	**Memo**								
Quality Control									
130		0.00							
130						6			13/12/19
Brake NC	**Memo**	0.00							
Brake NC	1-Deburr if necessary 2-Bend as per Dwg D3294 (Ensure angle is correct)			DAS 30 9-89					
140	QC5- Inspect part completeness to step on W/O	0.00				6			
140		0.00 13/12/19							
QC	**Memo**								
Quality Control									

DAS 27 9-89

DQA: [signature] Date: 14/01/24

QA Closed: [signature] Date: 14/1/8

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

Work Order update only ☐

Work Order: 109425

Part No. D3294-1

NCR No. 14-3390

DISPOSITION

Rework ☐
Scrap ☒
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☒ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ✓ Operator ☐ Offset/Setup ☐ Process ☐ Supplier ☐ Training ☐ Transport ☐ Unapproved ☐	3/12/10	130	6	part broke when forming RC grain direction PART WAS NOT CUT ON the water Jet in the correct orientation.	5 14/01/08 QZ2012	destroy + re-cut part M 127608 $11.76	13.12.11	DAS 27 9-89 R/12/11	DAS 27 9-89 R/12/11

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 109425

109425

November-21-13 2:23:06 PM

Item ID: D3294-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Bracket For Interior Window For -115 **Stop** *NS2*

Start Date: 11/21/13 **Start Qty:** 6.00 *6*

Required Date: 11/21/13 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center iD	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00				6		13-12-19	
150									
HandFinish	**Memo**	0.00							
Hand Finishing									
160	QC7-Inspect Chemical Conversion Coat	0.00				6x			DAS 36 9-89 13/12/20
160									
QC	**Memo**	0.00							
Quality Control									
170		0.00				6x			DAS 36 9-89 13/12/20
170									
Small Fab	**Memo**	0.00							
Small Fab	1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294								

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Marks/Chatter
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General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 109425

November-21-13 2:23:06 PM

109425

Item ID: D3294-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket For Interior Window For -115

Start Date: 11/21/13 **Start Qty:** 6.00 *6*

Required Date: 11/21/13 **Req'd Qty:** 6.00 *6*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC5- Inspect part completeness to step on W/O	0.00 DAS 27 9-89				6			
180 QC Quality Control	**Memo**	0.00 13/12/20							
190	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M 06878.	0.00							
190 Powdercoat Powder Coating	**Memo** Start Time: 10:25 Oven Temperature: 320° Finish Time: 10:55.	0.00				6 ϕ 13-12-20.			DAS 34 9-89
200	QC3- Inspect Part Finish	0.00							
200 QC Quality Control	**Memo**	0.00 DAS 27 9-89 13/12/23							DAS 34 9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
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☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
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General

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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D3294-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Bracket For Interior Window For -115
Start Date: 11/21/13 **Start Qty:** 6.00 *6* **Cust Item ID:**
Required Date: 11/21/13 **Req'd Qty:** 6.00 *6* **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start** *NR1*
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: ST212	0.00					DAS 28 9-89		
210						6X		13-12-27	
Packaging	**Memo**	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220								13/12/30	
QC	**Memo**	0.00							
Quality Control									

MF 13-12-30

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Cuffs
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☐ Inspection Strip in Tube
☐ Marks/Chatter
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General

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☐ BOM/Route
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☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

November-21-13 2:23:05 PM

Work Order ID: 109425

Parent Item: D3294-1 **Start Date:** 11/21/13 **Required Date:** 11/21/13

Parent Item Name: Bracket For Interior Window For -115 **Start Qty:** 6.00 **Required Qty:** 6.00

Comments: IPP A04.08.24New issueKJ/JLM
IPP Rev:B Now On Waterjet 07-03-26 JLM
IPP Rev:C 08-07-16 Redesign part DD verified by:EC
IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 2024-T3 .080 sheet		Purchased	No			100	sf	51.1700	1.8	~~11.36842T~~ 14+12		JM 13-12-7	
				Location		**Loc Qty**		**Loc Code**					
				MAT022		51.17					127668		
					123217	12.75							
					125636	18.42							
					M126161	20				126161			
D3294-5 Doubler		Manufactured	No			170	Each	8.0000	1	6	13/12/20		DAS 36 9-89
				Location		**Loc Qty**		**Loc Code**					
				GA		8							DAS 36 9-89
					104569	8				6			
MS20470AD4-5 RIVET, UNIVERSAL HEAD		Purchased	No			170	Each	2,477.0000	15	90	13/12/20		
				Location		**Loc Qty**		**Loc Code**					
				ST336		2477							
					125654	9							
					m126926	2468				90			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
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☐ Turning Sequence
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General

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☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD	Work Order:	109425
Description: BRACKET Assembly	Part Number:	3294-1
Inspection Dwg: D3294 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

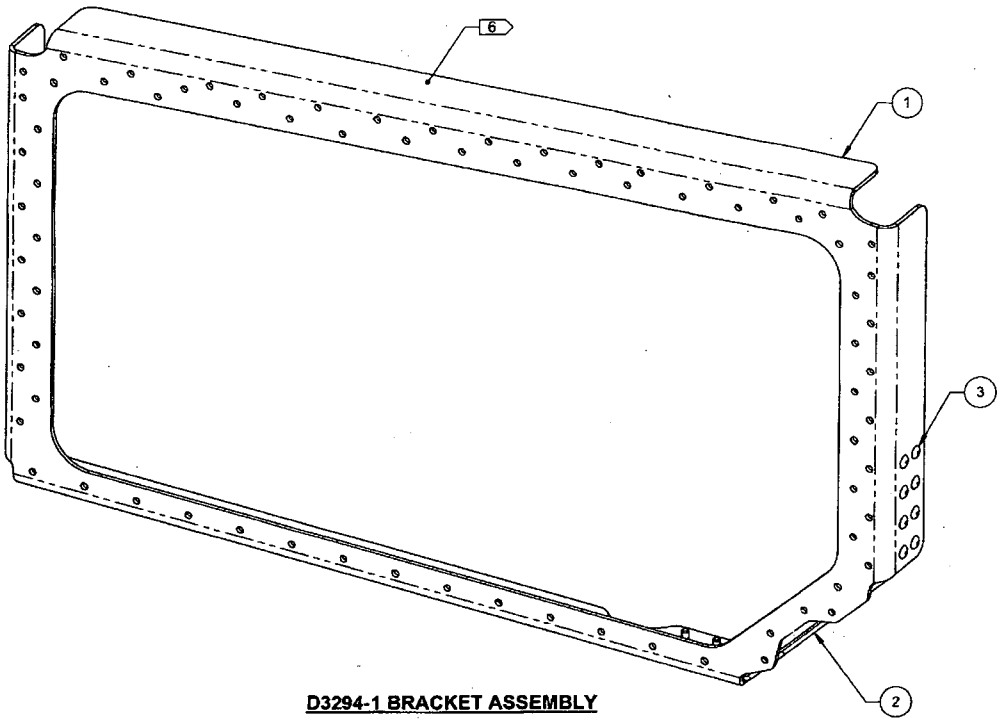
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+.005/-.001	.130	–		V	JKm-05
Ø .141	+.005/-.001	.142	–		V	
6.708	+/- .010	6.708	–		T	JKm-06
1.118	+/- .010	1.118	–		V	
5.590	+/- .010	5.590	–		T	
1.118	+/- .010	1.118	–		V	
13.563	+/- .010	13.563	–		T	
1.043	+/- .010	1.043	–		V	
.625	+/- .010	.625	–		V	
.325	+/- .010	.325	–		V	
.300	+/- .010	.300	–		V	
.400	+/- .010	.400	–		V	
6.000	+/- .010	6.000	–		T	
1.000	+/- .010	1.000	–		V	
17.124	+/- .010	17.124	–		T	
16.13	+/- .030	16.13	–		T	
7.27	+/- .030	7.27	–		T	
11.97	+/- .030	11.97	–		T	
8.37	+/- .030	8.37	–		T	
20.05	+/- .030	20.05	–		T	
12.98	+/- .030	12.98	–		T	
14.59	+/- .030	14.59	–		T	
11.66	+/- .030	11.66	–		T	
.080	+/- .010	.080	–		V	

Measured by:		Audited by:	SKP	Preliminary Approval:	
Date:	13.12.11	Date:	13/12/11	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

ITEM	QTY -1	P/N	DESCRIPTION
	X	D3294-1	BRACKET ASSEMBLY
1	1	D3294-3	BRACKET
2	1	D3294-5	DOUBLER
3	15	MS20470AD4-5	RIVET



D3294-1 BRACKET ASSEMBLY

109425 MCJ
13-11-25

RELEASED
2012 -11- 21

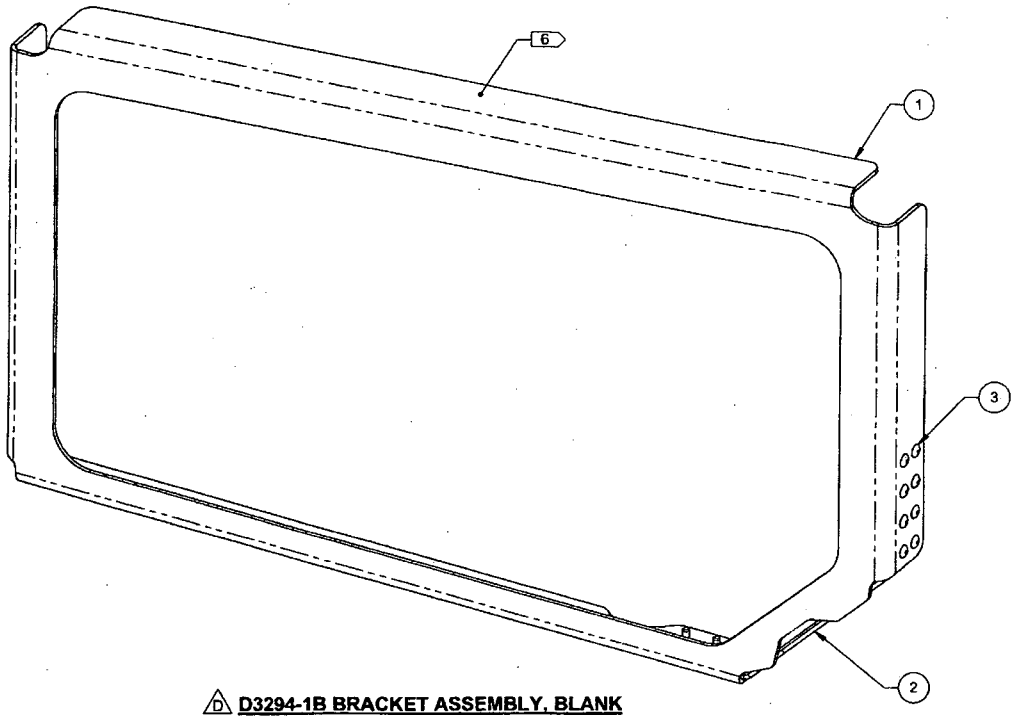
REV.	DESCRIPTION	BY	DATE
D	ADD D3294-1B/-3B/-3FB. REASON: PAR12-223.	MB	12.11.15
C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE, ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28

DESIGN	DART AEROSPACE LTD	
DRAWN	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWING NO. D3294	REV. D
MFG. APPR.		SHEET 1 OF 9
APPROVED	TITLE BRACKET	SCALE NTS
DE APPR.		
DATE 12.11.15		

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NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1" PER DART QSI 044 6.1
7) WEIGHT: 0.83 lbs

ITEM	QTY -1B	P/N	DESCRIPTION
	X	D3294-1B	BRACKET ASSEMBLY, BLANK
1	1	D3294-3B	BRACKET
2	1	D3294-5	DOUBLER
3	15	MS20470AD4-5	RIVET



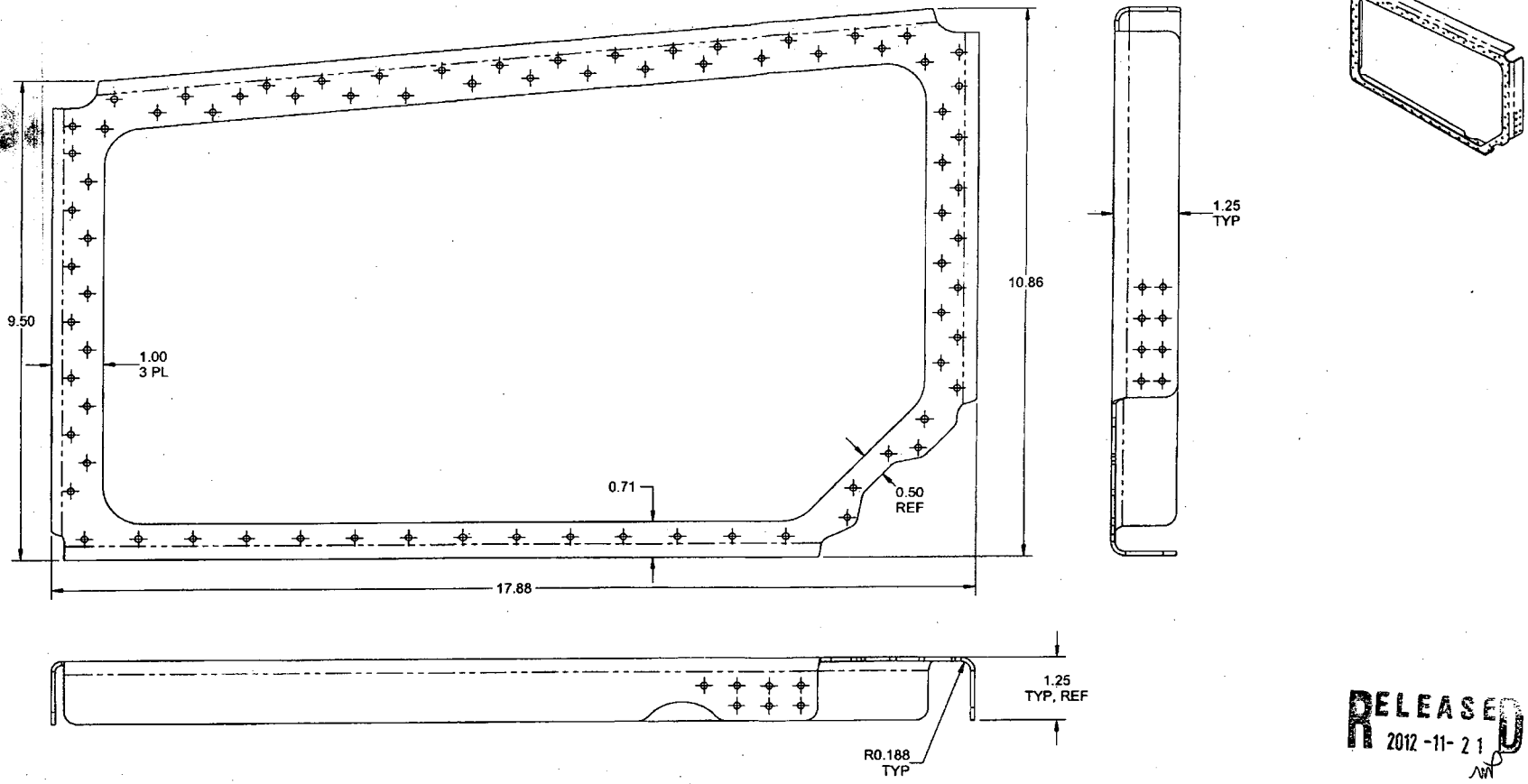
△D **D3294-1B BRACKET ASSEMBLY, BLANK**

RELEASED
2012 -11- 21

NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1B" PER DART QSI 044 6.1
7) WEIGHT: 0.83 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3294 REV. D
MFG. APPR.		SHEET 2 OF 9
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE 12.11.15		

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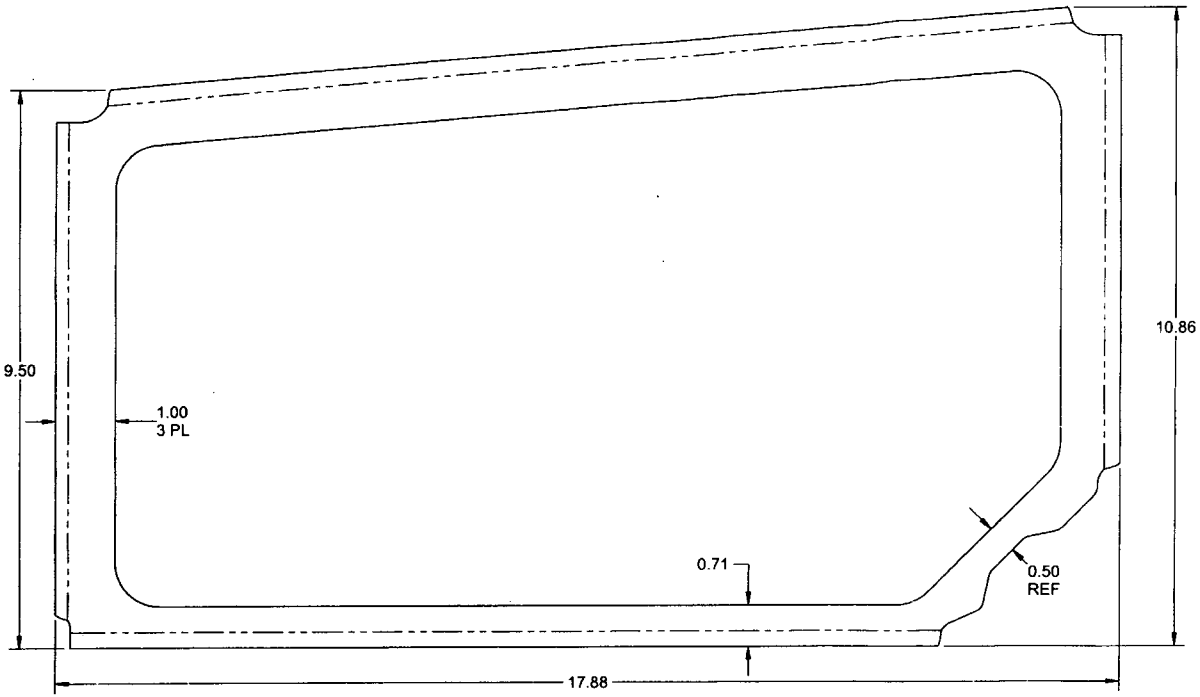
D3294-3 BRACKET
MADE FROM D3294-3F

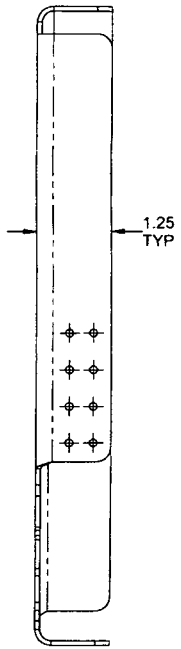
RELEASED
2012 -11- 21

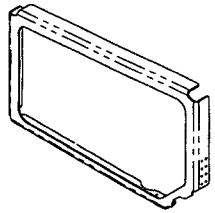
NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT OER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.75 lbs

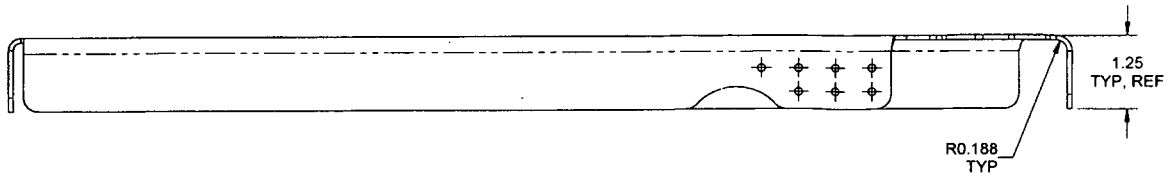
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3294 REV. D
MFG. APPR.		SHEET 3 OF 9
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE 12.11.15		

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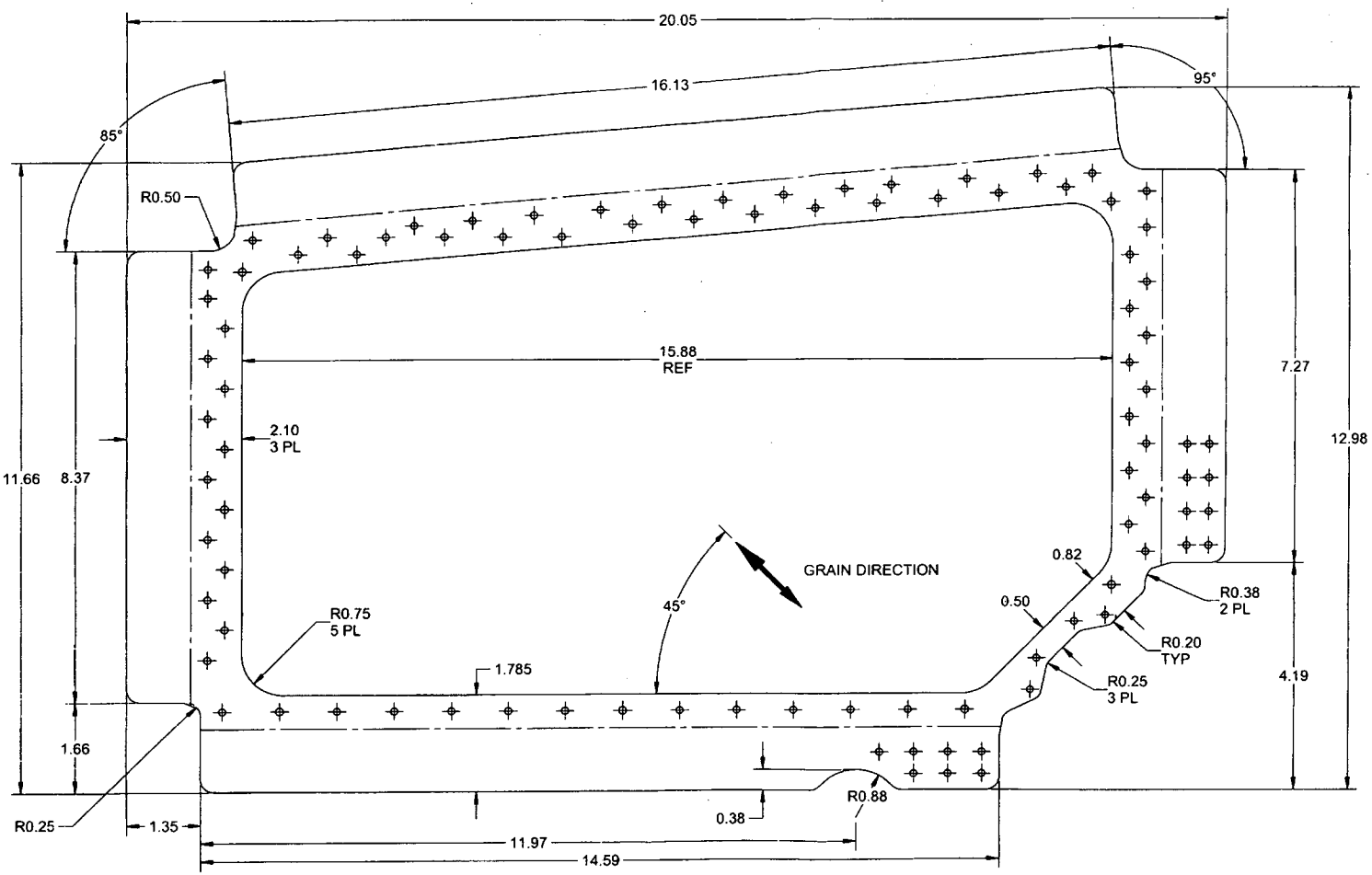
RELEASED
2012 -11- 21

D3294-3B BRACKET
(D) MADE FROM D3294-3BF

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT OER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.76 lbs

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3294 REV. D SHEET 4 OF 9
MFG. APPR.		
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
DATE 12.11.15		

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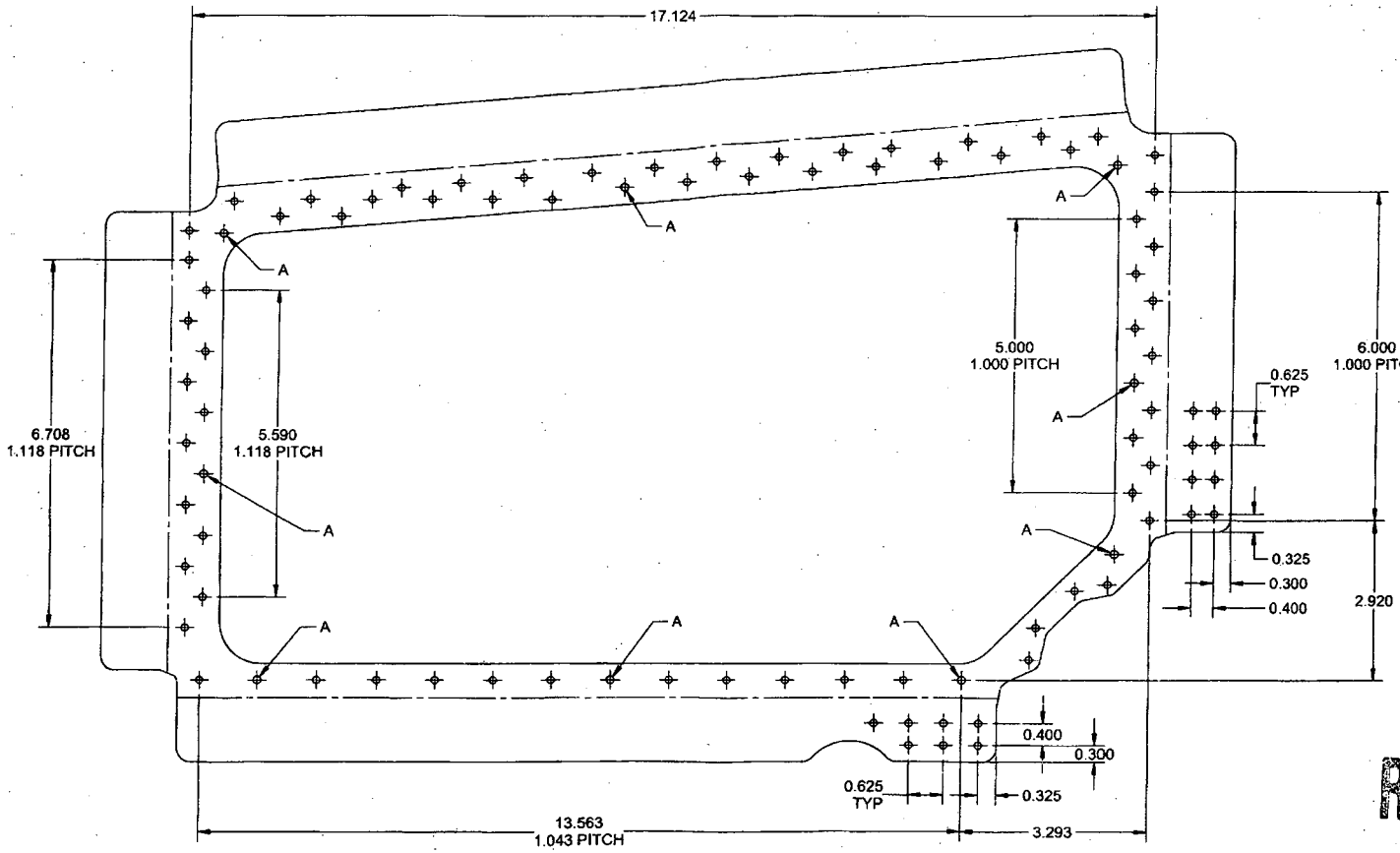
D3294-3F BRACKET FLAT PATTERN

RELEASED
2012 -11- 21

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.080)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3294 — REV. D
MFG. APPR.		SHEET 5 OF 9
APPROVED		TITLE: BRACKET — SCALE: NTS
DE APPR.		
DATE	12.11.15	

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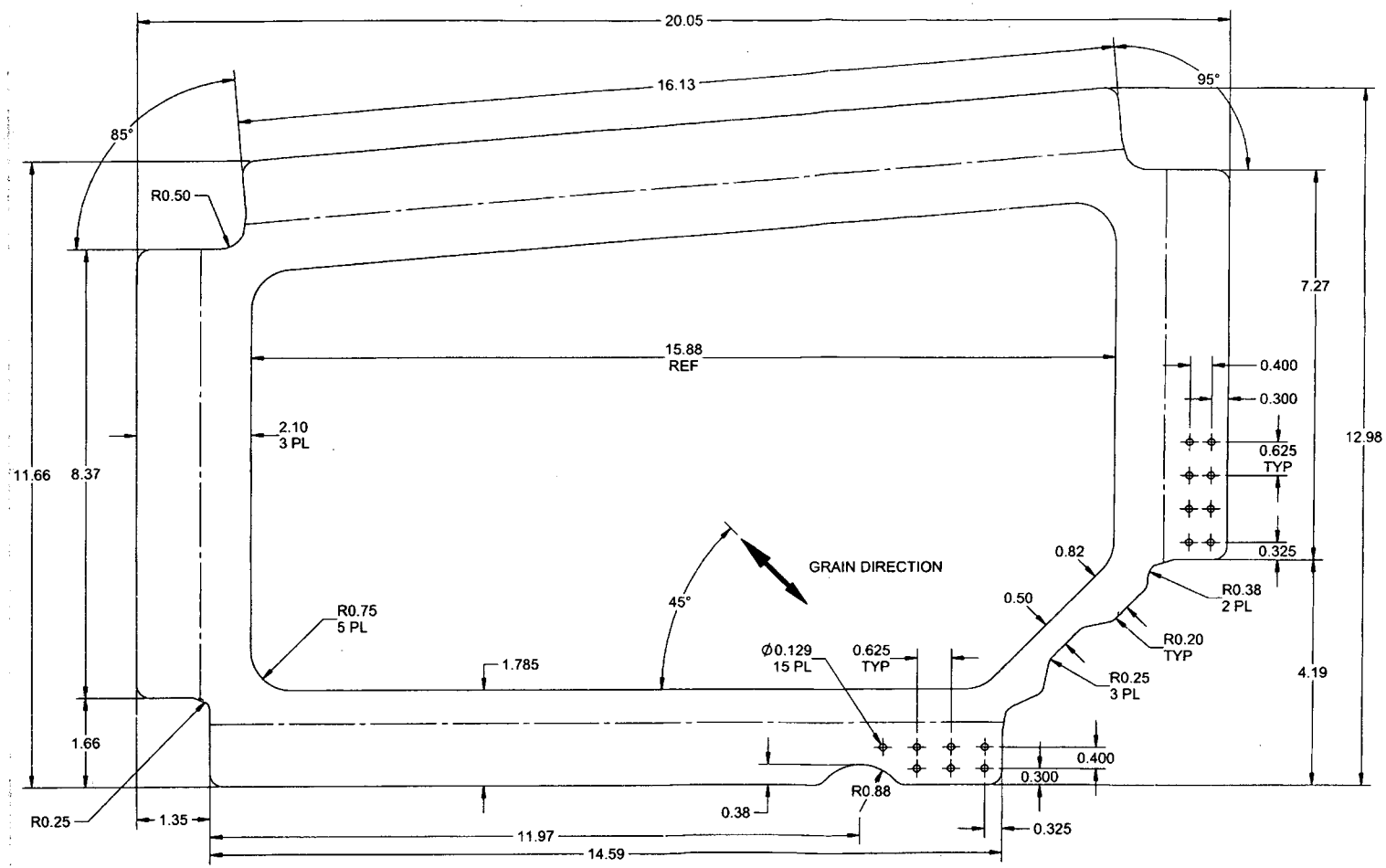
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2012 -11- 21

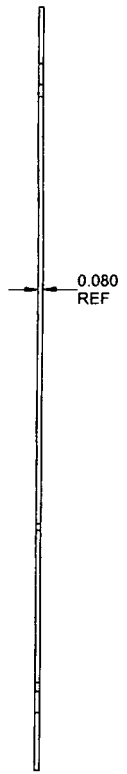
LABEL	HOLE Ø
ALL HOLES UNLESS NOTED	0.129
A	0.141

D3294-3F BRACKET FLAT PATTERN
SUPPLEMENTAL VIEW

DESIGN		**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. D3294 REV. D
MFG. APPR.		SHEET 6 OF 9
APPROVED		TITLE BRACKET SCALE NTS
DE APPR.		
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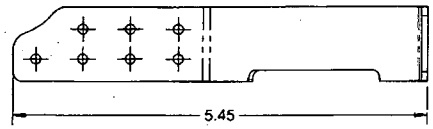
RELEASED
2012 -11- 21

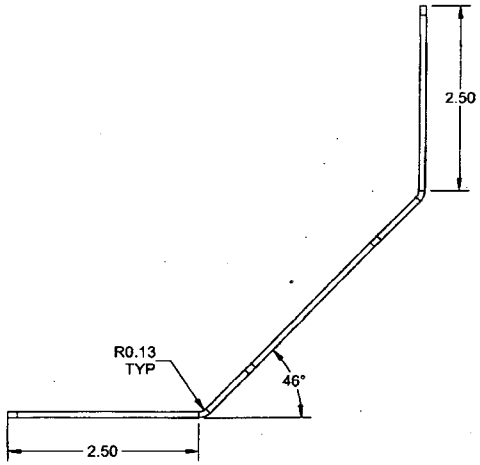
D3294-3BF BRACKET FLAT PATTERN, BLANK

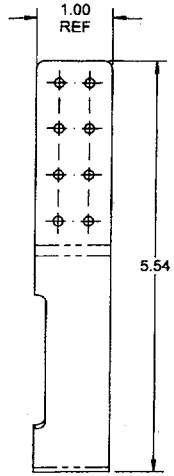
NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.080)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.75 lbs

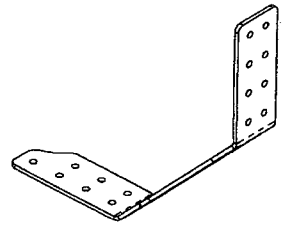
DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3294 REV. D
MFG. APPR.		SHEET 7 OF 9
APPROVED		TITLE BRACKET
DE APPR.		SCALE NTS
DATE 12.11.15		

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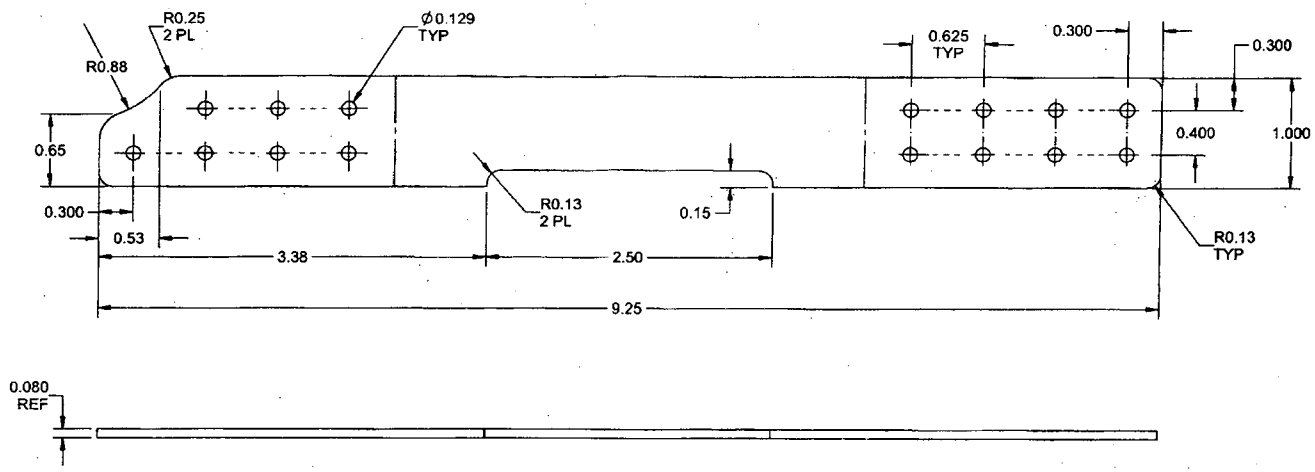
D3294-5 DOUBLER
MADE FROM D3294-5F

RELEASED
2012 -11- 21

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		DRAWING NO. REV. D
CHECKED		D3294 SHEET 8 OF 9
MFG. APPR.		TITLE SCALE
APPROVED		BRACKET NTS
DE APPR.		
DATE 12.11.15		

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D3294-5F DOUBLER FLAT-PATTERN

RELEASED
2012 -11- 21

NOTES:
1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209 (REF DART SPEC M2024T3S.080)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.07 lbs

DESIGN		**DART AEROSPACE LTD**
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D3294 — REV. D
MFG. APPR.		SHEET 9 OF 9
APPROVED		TITLE: BRACKET — SCALE: NTS
DE APPR.		
DATE 12.11.15		

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